

# Work Order ID 60046

Wednesday, June 23, 2010 1:12:12 PM



Page 1

Item ID: D3916-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly

Stop



Start Date: 6/23/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/30/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

*H*

Date: 10-6-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3916

A

100

0.00



Large Fab

Large Fab

Memo

0.00

- 1- Cut tube 50"
- 2- Bend tube with manuel pipe bender as per DT9567
- \*\*\* Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending\*\*\*
- 3- Trim access tube material to finish size as per dwg D3916
- 4- Drill and chamfer holes as per dwg D3916-1 using DT9605
- 5- weld bushing as per dwg D3916
- 6- grind welds flush

8A0 10-07-13

⑥ Cpl 10-07-20

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Scot 10/7/21

⑥

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 60046**

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Item ID: D3916-041

Revision ID:

Item Name: Rib Assembly

Start Date: 6/23/2010 Start Qty: 6.00

Required Date: 6/30/2010 Req'd Qty: 6.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC10- Inspect visual per QSI004- ground welds

0.00

0.00

8/10/07/21

(16)

QC

Quality Control

Memo

130

Identify as per dwg &amp; Stock Location: WA

0.00

0.00

SAD

10-07-21

(16)

Packaging

Packaging

Memo

140

QC21- Final Inspection - Work Order Release

0.00

0.00

QC

Quality Control

Memo

10/07/21

MF

10-7-21

W/O:		WORK ORDER CHANGES						
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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, June 23, 2010 1:12:16 PM

Page 1

Work Order ID: 60046

Parent Item: D3916-041

Parent Item Name: Rib Assembly

Start Date: 6/23/2010

Required Date: 6/30/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC  
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1		Manufactured	No			100	Each	90.0000	7	42			
Bushing													

## Location

## Loc Qty

## Loc Code

WA	90	
54072	9	
59419	39	
59644	42	

100 f

441.5314 4.166 26.31158



SAD 10-07-13

M304TS0.750W.049

Purchased

No



304 SQ Tube .75x.75x.049W

## Location

## Loc Qty

## Loc Code

MAT	141.5313919	
113763	0	
114323	28.3020789	
114677	14.34201	
114835	98.887303	
MAT017	3.68448E-05	
114298	3.6845E-05	
WA	300	
114992	300	

26.31158

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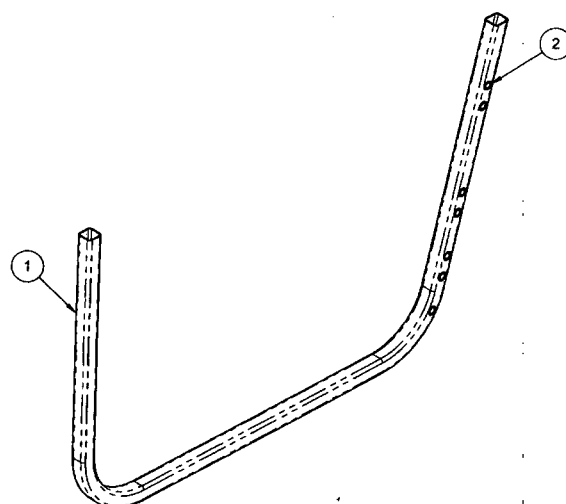
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

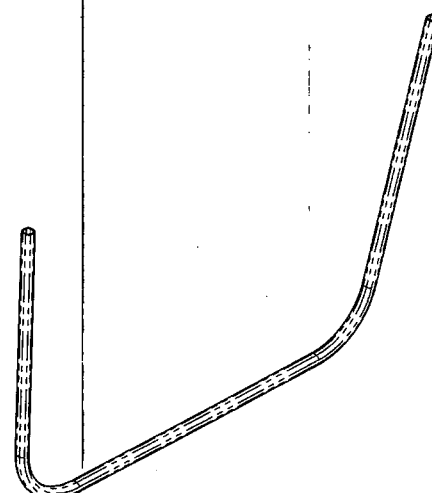
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**NOTE:** Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



**D3916-041 RIB ASSY**



**D3916-5 LIGHT RIB**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 600-46

*BS10-6-23*

**RELEASED**  
2010-03-12  
*JWP*

A		NEW ISSUE		JPH		10.03.04	
REV.		DESCRIPTION		BY		DATE	
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		DRAWING NO. <b>D3916</b>		REV. A SHEET 1 OF 4	
DRAWN	JPH						
CHECKED	<i>[Signature]</i>	TITLE		SCALE		NTS	
MFG. APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET					
APPROVED	<i>[Signature]</i>						
DE APPR.	<i>[Signature]</i>						
DATE	10.03.04						

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W/O:		WORK ORDER CHANGES					
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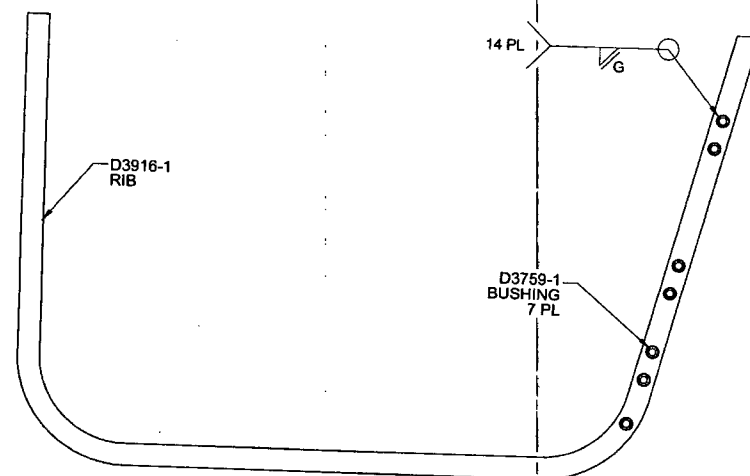
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**NOTE:** Date & initial all entries





**D3916-041 RIB ASSY**

WLO 60046

**RELEASED**  
2010-03-12  
ANT

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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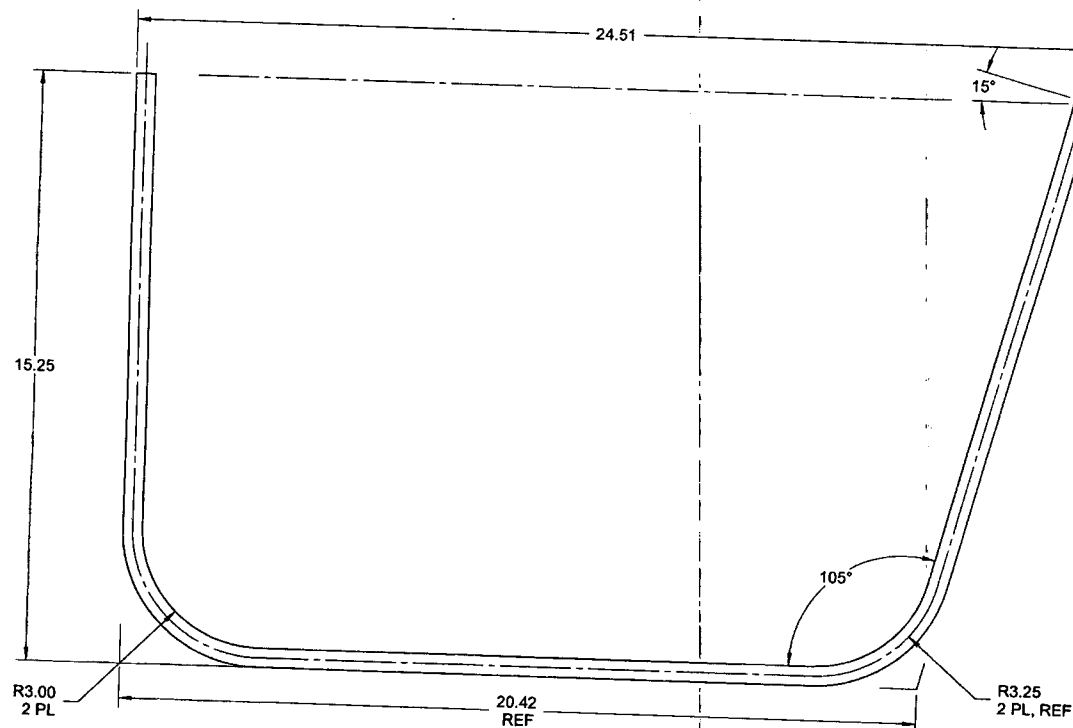
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**NOTE:** Date & initial all entries



9 D3916-5 LIGHT RIB

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

**RELEASED**  
2010-03-12

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 4 OF 4
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